

SHIP MAY 29

Work Order ID 133047

133047

Page 1

Item ID: D412-785-003-403

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pax Speaker Mount, Fwd

Start Date: 5/29/15 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 5/29/15 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: JD Date: 15-5-25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-785-003-101	C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: CProg Rev: C

2-Deburr if necessary

2 0 JM15-5-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2 0 JM15-5-25

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

(2) JB 15-05-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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Work Order ID 133047

Monday, May 25, 2015 9:03:33 AM

133047

Page 2

Item ID: D412-785-003-403

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pax Speaker Mount, Fwd

Start Date: 5/29/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/29/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
36
9-89

130

130

Small Fab

Small Fab

Memo

0.00

Small Fab

c'sink as per dwg

150

150

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

0.00

DAS
36
9-89
MAY 25, 2015

160

160

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐							

Work Order ID 133047

Monday, May 25, 2015 9:03:33 AM

133047

Page 3

Item ID: D412-785-003-403

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Pax Speaker Mount, Fwd

Stop

NS2

Start Date: 5/29/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/29/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

D46

38

9-89

MAY 26 2015

180

Identify as per dwg & Stock Location: PPP121605

0.00

180

Packaging

Memo

0.00

Packaging

D46

27

9-89

MAY 26 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

ML5

MAY 27 2015

MF
15-5-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, May 25, 2015 9:03:37 AM

Page 1

Work Order ID: 133047

133047

Parent Item: D412-785-003-403

D412-785-003-403

Parent Item Name: Pax Speaker Mount, Fwd

Start Date: 5/29/15

Required Date: 5/29/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-09-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

Purchased

No

sf

29.8882

2

M2024T3S 040

**

JM15-5-25

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

29.8882

m130497

29.8882

130497

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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		OTHER : ☐			

TRANSFER DRILL 4X Ø0.203 HOLE FROM
D412-785-003-201/-203 SPEAKER MOUNT TO AIRFRAME
TRANSFER DRILL 8X Ø0.098 HOLES FROM
MS21069L3 ANCHOR NUTS (CENTERED ON
PREVIOUSLY DRILLED HOLES) TO AIRFRAME
COUNTERSINK 8X Ø0.179 X 100°
ATTACH MS21069L3 ANCHOR NUTS USING
MS20426AD3-4 RIVETS
ATTACH D412-785-003-201/-203 SPEAKER
MOUNTS USING AN525-10R7 TO MS21069L3
ANCHOR NUTS
6 PLACES TYP

PASSENGER ADDRESS SPEAKER
ATTACH USING MS27039-806

D412-785-003-201
SPEAKER MOUNT AFT SHOWN
4 PL
D412-785-003-203
SPEAKER MOUNT FORWARD SIMILAR
2 PL

CABIN ROOF
REF

SPEAKERS MOUNTED
IN LIGHTENING HOLES
AT THESE LOCATIONS

STN 84

STN 110

STN 139

BL +36

BL 0.0

BL -36

D412-785-003-203
2 PL

D412-785-003-201
2 PL

D412-785-003-201
2 PL

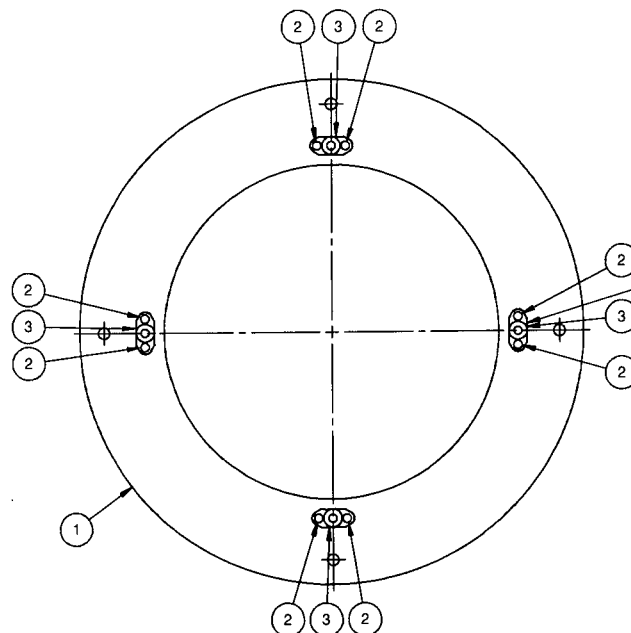
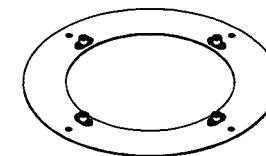
ITEM NO.	QTY. -101	PART NO.	DESCRIPTION
1	4	D412-785-003-201	SPEAKER MOUNT
2	2	D412-785-003-203	SPEAKER MOUNT
3	6	TR650-Cxi	SPEAKER
4	24	AN525-10R7	SCREW
5	24	MS27039-806	SCREW
6	24	MS21069L3	ANCHOR NUT

D412-785-003-101 PASSENGER SPEAKER MOUNT INSTALLATION

AD 5-25

C	REVISE ANCHOR NUT P/N SHEET 2-5	HS	12.04.04
B	UPDATE FOR LSTC	HS	09.10.09
A	NEW ISSUE	HS	08.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	<i>[Signature]</i>	CALGARY, ALBERTA, CANADA	
CHECKED	N/A	DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-785-003-101	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
DATE	12.04.04	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.	

ITEM NO.	QTY. -201	PART NUMBER	DESCRIPTION
1	1	D412-785-003-401	PAX SPKR MOUNT, AFT
2	8	MS20426AD3(-4)	RIVET
3	4	MS21069L08	ANCHOR NUT



INSTALL MS21069L08 ANCHOR NUT
USING MS20426AD3 RIVETS
4 PL

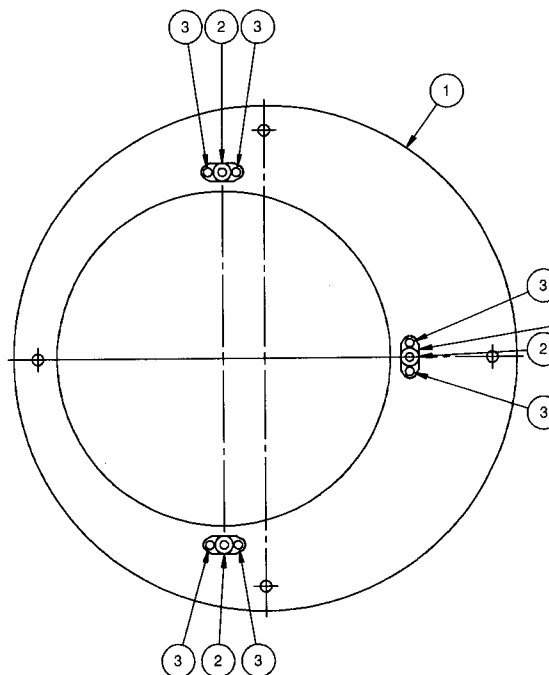
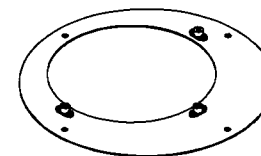
D412-785-003-201 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N D412-785-003-201 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.12 lbs

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-785-003-101	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
DATE	12.04.04	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD	

ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-003-403	SPEAKER MOUNT, FWD
2	3	MS21069L08	ANCHOR NUT
3	6	MS20426AD3(-4)	RIVET



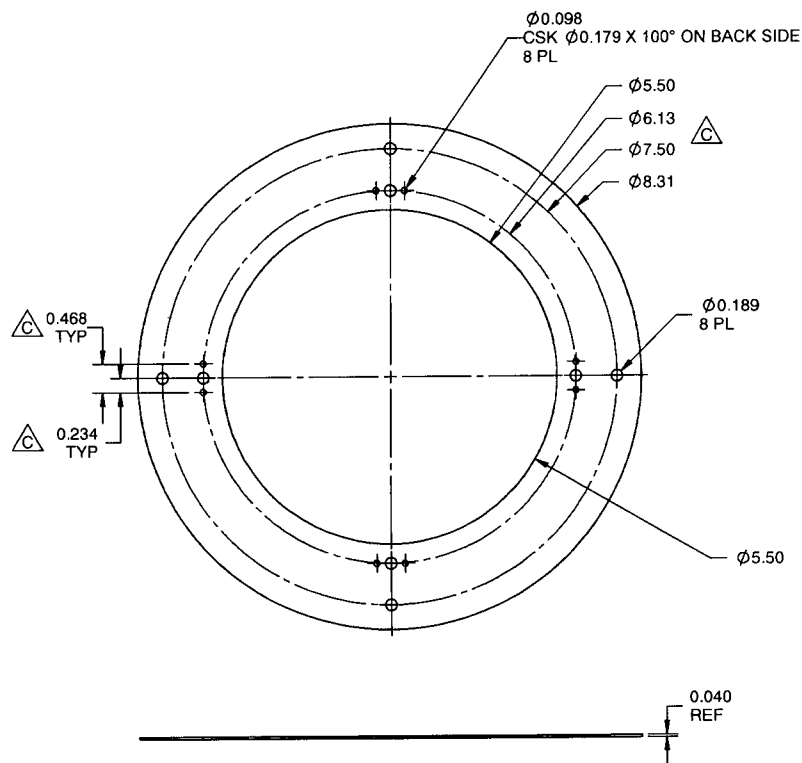
INSTALL MS21069L08 ANCHOR NUT
USING MS20426AD3 RIVETS
3 PL

D412-785-003-203 PAX SPEAKER MOUNT FWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N "D412-785-003-203 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.05 lbs

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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-785-003-101	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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D412-785-003-401 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
- 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-785-003-101	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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